

Date: Thursday, 02/10/2008 10:34:21 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : CLAMP
<b>Job Number</b> : 42407	
<b>Estimate Number</b> : 10600	
<b>P.O. Number</b> :	<b>Part Number</b> : D2519
<b>This Issue</b> : 02/10/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2519 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 41430	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/10/2008 <b>Qty:</b> 50 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 08.10.02</u>	
<b>Comment</b> : Est: B 00.03.16 Re-format, laser cutting EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 7299~~Laser cut~~ as per Dwg D2519

Material release note required

CFI

C 208/10/02 (50)

2.0	D2519F	Clamp
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Clamp

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

R 8/23 (50)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

(8.561" center to center)

508/10/23 (K50) counts

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr any rough edges after tumbling

2-Bend as per Dwg D2519

n/a 5/10/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 42407

Part Number: D2519

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



PO

Comment: INSPECT WORK TO CURRENT STEP

Sosluco counter

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Tumble HB 8-11-10

ASO

8.0

PACKAGING 1

PACKAGING RESOURCE #1



SO

Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: 451

8/11/10

SO

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
01/10/10	# 6 & 7	change orientation of steps #6 and 7. tumble should be before inspect @ QCS				<i>[Signature]</i> 08-11-10	<i>[Signature]</i> 01/11/10

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

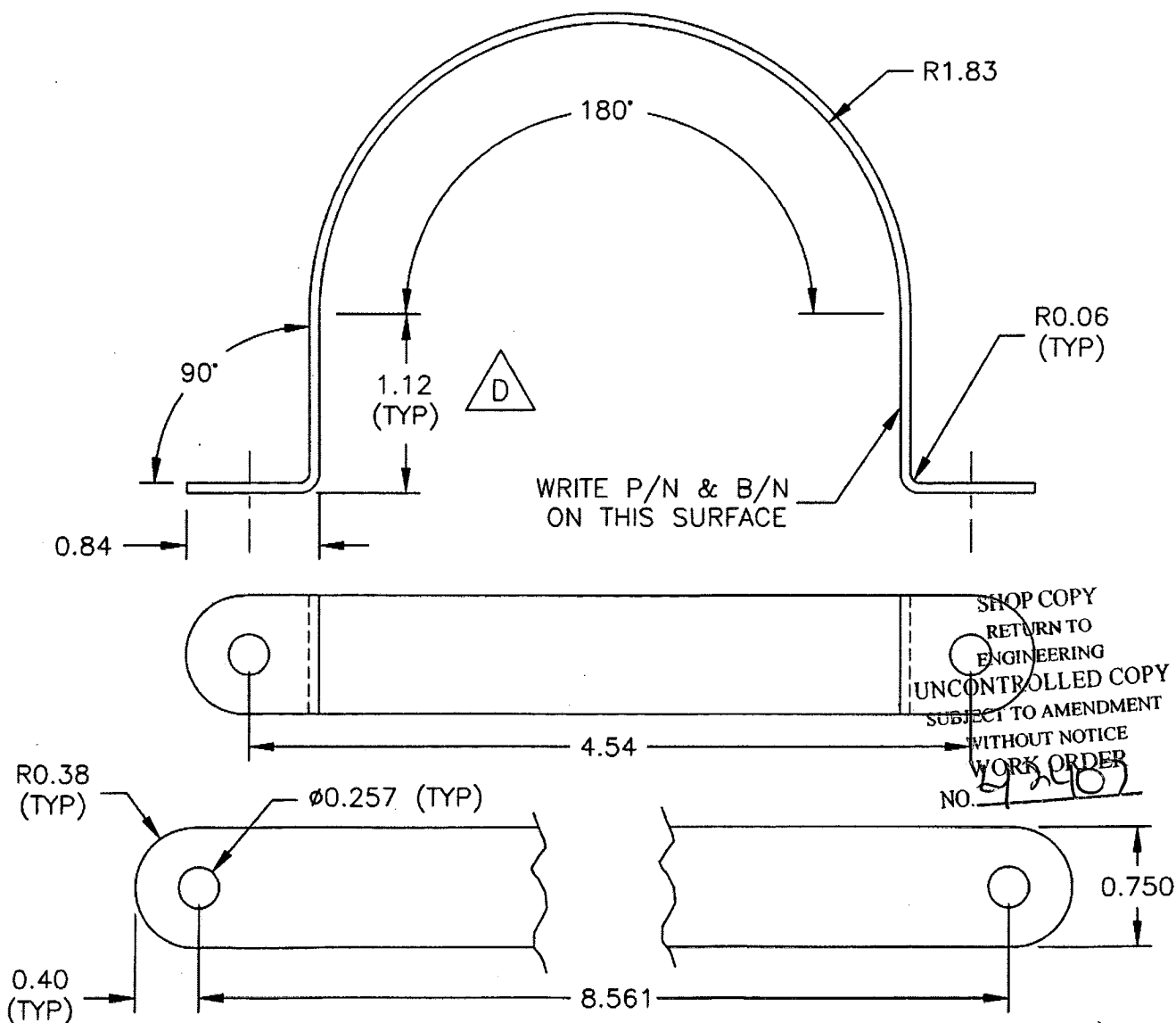
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2519	REV. D SHEET 1 OF 1
DATE 04.11.08		TITLE CLAMP	SCALE 1:1
A	95.11.28	NEW ISSUE	
B	97.03.24	ADD MATERIAL SPECIFICATION	
C	00.02.29	REDRAWN; ADDED FLAT PATTERN	
D	04.11.08	1.12 WAS 0.93	

RELEASED  
04.11.26 *[Signature]*



### D2519 FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK, (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSION ARE IN INCHES
- 4) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER ON SURFACE SHOWN

**CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE**



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 4 OUR JOB NO J0191902 SHIPPING MEMO 0406147

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
--	<u>50 PCS</u>	<u>PO00007299</u>	<u>D2519F</u>	<u>D</u>	<u>CLAMP</u>	<u>D</u>

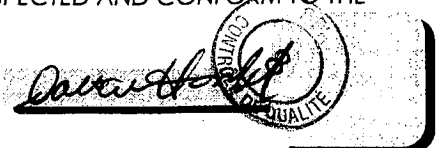
MATERIAL S.S.T 304 SUPPLIED BY SAMUEL / AK STEEL MAT. REL. NO. 7380365 ATT'D

	PROCESS	PROCESSOR	RELEASE NOTE #
1			
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 22 OCTOBER 2008

G.F.I. Q.C. REP.





Programme d'Assurance Qualité Enregistré / Registered Q.A. Program  
ISO 9001:2000 AS9100

**LETTRE DE CONFORMITÉ --LETTER OF COMPLIANCE**

Date: 19 SEPTEMBRE 2008

Company Name: G.F.I. Division of Thomas & Betts limited  
Address: 180 avenue Labrosse  
City: Pointe Claire, Qué.  
Zip Code: H9R 1A1

# du client: CC03625  
Customer's order #:

# de commande SSMQ: 883582  
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:


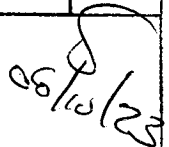

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
2	15	.060" X 48" X 96"	304 2B		7380365

Bien à vous,  
Yours truly,



*Marc Grippeth*

Commis à l'administration.  
Administration Clerk.

		<b>AK Steel Corporation</b> <b>Metallurgical Test Report</b> <b>Rockport Works</b> <b>Rockport, IN 47635</b>		Page 1												
				Load No. 8970283 SRN No. 8970283												
CUSTOMER	SAMUEL & FILS & CIE LTEE (S) PUR DEPT 2225 FRANCIS HUGHES DRIVE LAVAL, CN H7S1N 5		SHIP TO	SAMUEL & FILES (QUEBEC) LTEE 2225 FRANCIS HUGHES LAVAL, CN H7S1N-5												
	MILL ORDER NO. 252502-1172 PART NO. ENGLISH UNITS --PRODUCT-- METRIC UNITS .0590 NOM 48.0000 X COIL			PROCESSOR ORDER NO. C10360-3 BUYERS ORDER NO. C10360-3												
COIL ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT	OUTSIDE PROCESSOR ID											
127733-01BAAB	1	7380365	0127733-01BAA	19,960 LBS. 9,054 KG.	466346002											
TOTAL COILS	TOTAL PIECES			TOTAL NET WEIGHT												
1	1			19,960 LBS. 9,054 KG.												
L-Ladle Analysis of Heat      P-Product Analysis of Parent Coil <b>CHEMICAL ANALYSIS</b>																
ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
L 7380365	.023	1.240	.025	.0026	.385	18.11	8.09	.29	.0330	.44						
SHIPPING DATE: 06/14/2008      REMARKS: NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS WERE MADE OR USED THROUGHOUT THE PROCESSING AND TESTING OF THIS MATERIAL MATERIAL FREE OF RADIOACTIVE ISOTOPES																
<b>PRODUCT DESCRIPTION</b> CR SHT TYPE 304/304L STAINLESS #2B FINISH SLIT EDGE TEST REPORTS * ASTM A 240 -07 * ASTM A 480 -06 EX PARA 25.1.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY * ASME SA-240 SECTION II PART A (2004 ED, 2005 ADDENDA) * ASME SA-480 SECTION II PART A (2004 ED, 2005 ADDENDA) * ASTM A 262 -02A2 PRACTICE E * ASTM A 666 -03 EX 7.1 TEST SPECIMENS WILL BE SELECTED IN THE TRANSVERSE TEST DIRECTION IN ALL CASES.																
PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	% ELONG	TENSILE STRENGTH (KSI)	Y.S. .2% OFFSET (KSI)	ROCKWELL HARDNESS Tail	ROCKWELL HARDNESS Front								
0127733-01BAA	T	T	A.S.T.M	58.8	98.6	45.1	B 83	B 84								
PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	ASTM A 262 PRACTICE E	BEND 180 IT											
0127733-01BAA	T		A.S.T.M	PASS	PASS											
THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT AS QUANTIFIED IN THE RECORDS OF THE CORPORATION. ALL TESTING IS DONE IN ACCORDANCE WITH A.S.T.M. STANDARDS UNLESS OTHERWISE NOTED AK Steel Corporation      MWJCFWJW 5/08						THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSIGNEE OF MATERIAL PURCHASED FROM AK Steel Corporation. TO AVOID THE POSSIBILITY OF ITS ABUSE, ON DELIVERY OF THE REPORT TO A THIRD PARTY IT MUST BE RECERTIFIED BY AND UNDER THE NAME OF SUCH CONSIGNEE. SIGNED:  DATE 06/15/2008 TIME 05:57 AM RYAN MARTIN QUALITY MANAGER										